Work Order ID 120783

Wednesday, June 11, 2014 10:32:42 AM

120783

Item ID: D4634-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Fwd, Center Ceiling Panel **Stop** *NS2*

Start Date: 7/02/14 **Start Qty:** 1.00 *1*

Required Date: 7/02/14 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** 14-6-14 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D4634 / F									
100		0.00							DAS 07 9-89
100	HAND FINISHING THERMOFORMING					Y(			
Thermoform	**Memo**	0.00							14/06/16
Thermoforming Machine	Cut Blanks								
105		0.00							DAS 07 9-89
105	Dry Material					Y(			
HandThermo	**Memo**	0.00							14/06/16
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								

Temp: 245 deg. F

Time IN: 5:00 PM ~~6:00 AM~~

Time OUT: _____

JUN 16 2014

Per.....

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Item ID: D4634-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd, Center Ceiling Panel
Start Date: 7/02/14 **Start Qty:** 1.00 *1*
Required Date: 7/02/14 **Req'd Qty:** 1.00 *1*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							DAS 07 9-89
110	THERMOFORMING MACHINE					x1			
Thermoform	**Memo**	0.00							
Thermoforming Machine	Thermoform as per Dwg. D4634-1 and Folio FTA144								14/06/16
	Dwg. Rev. F								
	Folio Rev. E								
	NOTE: Check moulds prior to using to ensure proper placement of add-ons.								
	Visually inspect for proper formation and texture								
130		0.00							DAS 07 9-89
130	HAND FINISHING THERMOFORMING					x1			
Thermoform	**Memo**	0.00							
Thermoforming Machine	Trim to Finished Dimensions								14/06/23

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Heat Treat
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☐ Marks/Chatter
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☐ Broken/Damage/Defect
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☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4634-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd, Center Ceiling Panel
Start Date: 7/02/14 **Start Qty:** 1.00 *1*
Required Date: 7/02/14 **Req'd Qty:** 1.00 *1*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	~~QC6~~- Inspect dimensions to drawing Dimensional Inspection	0.00 SMT 14/6/29							
	Memo Fill in Inspection Sheet Rev A	0.00							
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00 DAS 16 9-89 14/6/29							
	Memo	0.00							
160 *160* Packaging Packaging	Packaging	0.00				(1) SAD 4/6/29			
	Memo Section: MF	0.00							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

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Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4634-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd, Center Ceiling Panel
Start Date: 7/02/14 **Start Qty:** 1.00 *1*
Required Date: 7/02/14 **Req'd Qty:** 1.00 *1*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00					14/7/30		
170									
QC	**Memo**	0.00							
Quality Control									

CMF 14-7-29

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

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Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Marks/Chatter
☐ Turning Sequence
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☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

Wednesday, June 11, 2014 10:32:41 AM

Work Order ID: 120783

120783

Parent Item: D4634-1

D4634-1

Parent Item Name: Fwd, Center Ceiling Panel

Start Date: 7/02/14 **Required Date:** 7/02/14

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev.A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update 13/07/09 DL verf:DD IPP Rev C Dwg Update, Material Change 13/12/18 DL IPP Rev D Dwg Update Change Mtl Qty. 14/01/20 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,148.443	17.3	18			~~DAS~~ 07 ~~9-89~~
MLEXS.093-F6006-07									**				
GE PLASTICS LEXAN SHEET (Grey)													

14/06/17

Location	Loc Qty	Loc Code	
MAT023	1148.44332		
114459	229.26		
123105	38		
124501	543.5		
m128668	181.35		
m129014	156.33332		

179471

18 sq ft.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

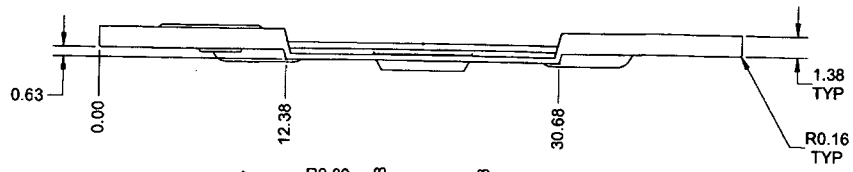
FAULT CATEGORY

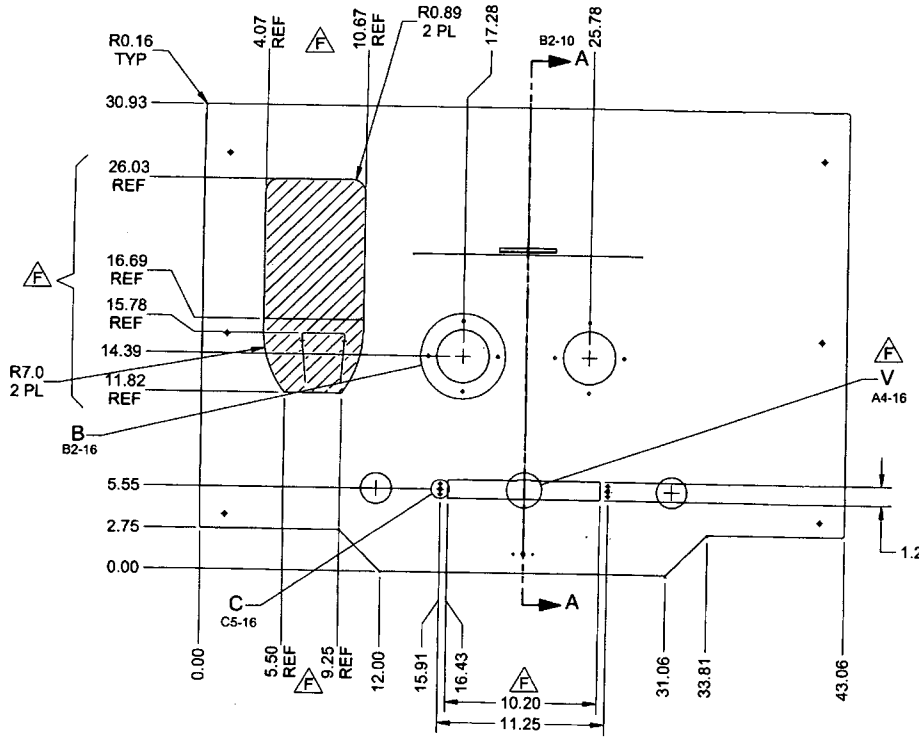
Landing Gear

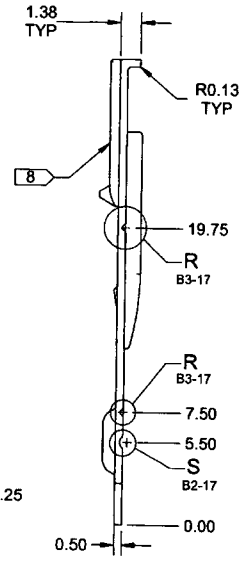
☐ Bending
☐ Centre Not Concentric
☐ Cracks
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☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

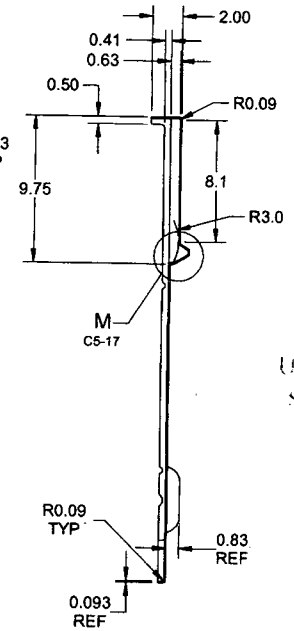
General

☐ Bend
☐ BOM/Route
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☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other









SECTION A-A C6-10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120783MP
14-6-11

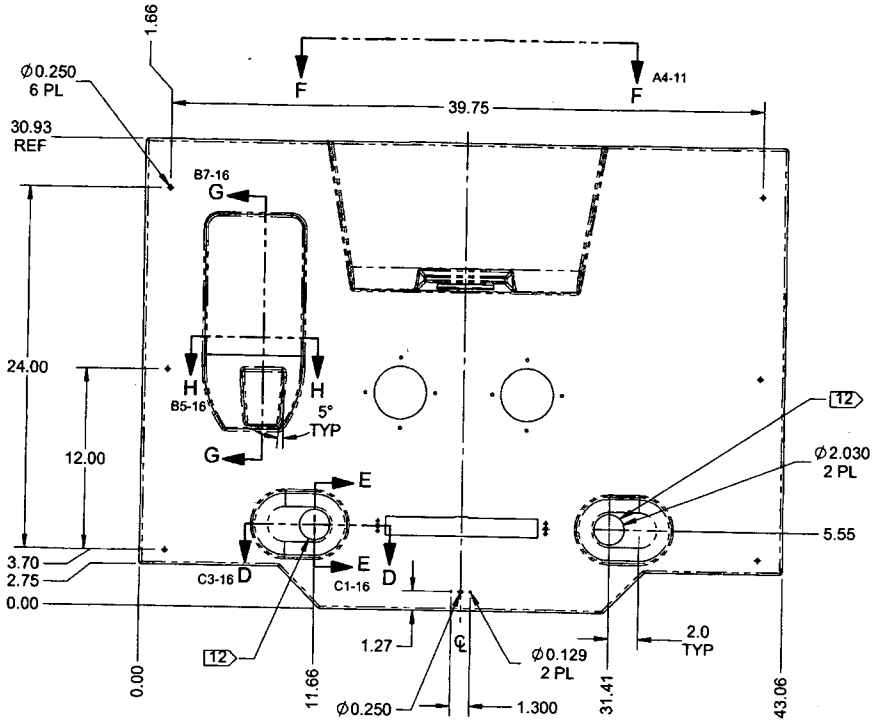
NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 5.65 lbs
8) TEXTURE ON THIS SIDE
9) 0.14 RADIUS NOT SHOWN FOR CLARITY
10) DRILL & TRIM D4634-1 PER TOOL DT9836
11) THERMOFORM PER QSI 022 USING DT9844 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.020
EDGES = 0.060
ELSEWHERE = 0.070
12) LOCATE Ø2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

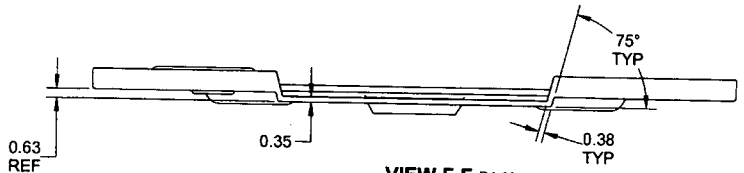
D4634-1 FWD, CENTER CEILING PANEL

RELEASED
2014 FEB 25

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. F
CHECKED		D4634	SHEET 10 OF 17
MFG. APPR.		TITLE	SCALE
APPROVED		CENTER CEILING PANELS	NTS
DE APPR.			
DATE	14.02.03		

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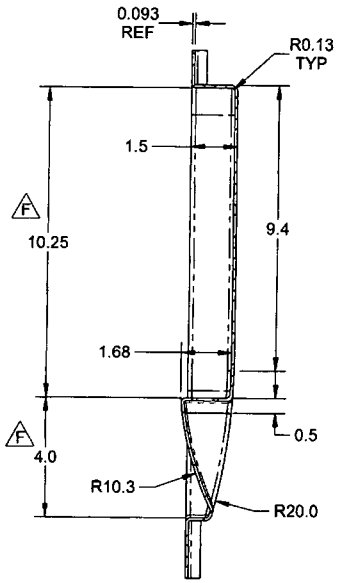
VIEW F-F D4-11

D4634-1 FWD, CENTER CEILING PANEL
AUXILIARY VIEW

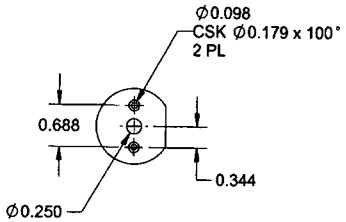
RELEASED
2014 FEB 25

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4634 REV. F
CHECKED	BC	SHEET 11 OF 17
MFG. APPR.		TITLE CENTER CEILING PANELS SCALE NTS
APPROVED		
DE APPR.		
DATE	14.02.03	

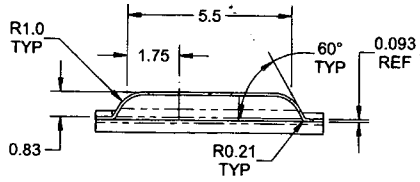
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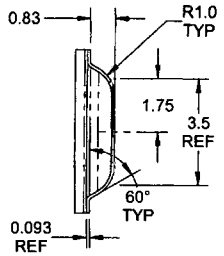
SECTION G-G C5-11
SCALE 4X



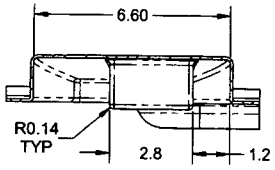
DETAIL C B7-10 B4-12 B4-14
SCALE 4X



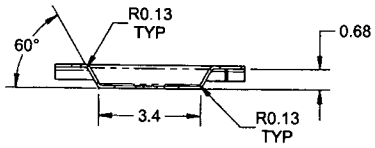
SECTION D-D B6-11 C4-13 C4-15
SCALE 2X



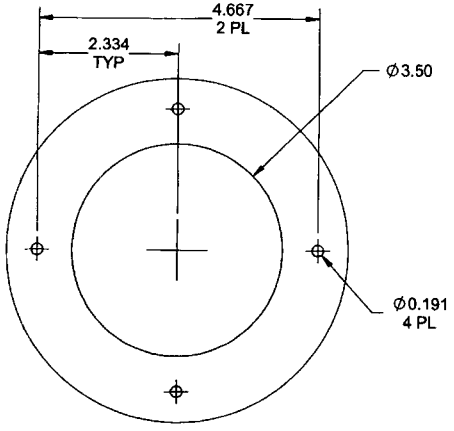
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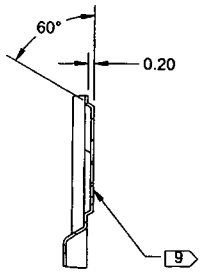
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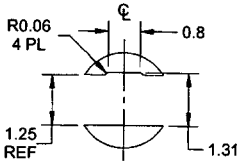
SECTION J-J B6-13
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DETAIL B B7-10
SCALE 4X
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DETAIL L B2-13 C2-13 B2-14 C2-14
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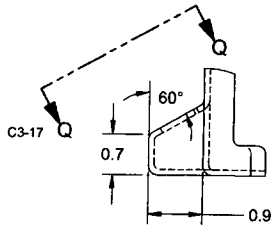


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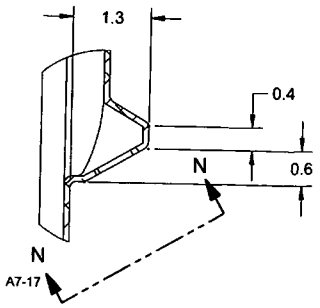
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DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4634 REV. F
CHECKED	DC	SHEET 16 OF 17
MFG. APPR.		TITLE CENTER CEILING PANELS SCALE NTS
APPROVED		
DE APPR.		
DATE	14.02.03	

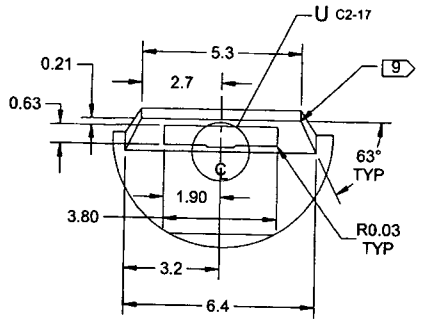
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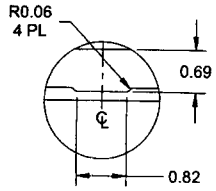
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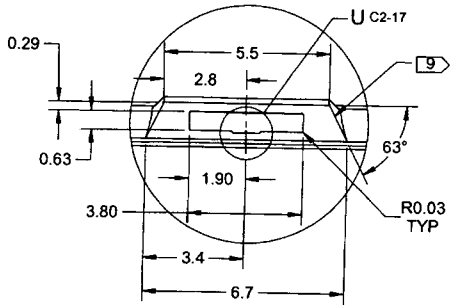
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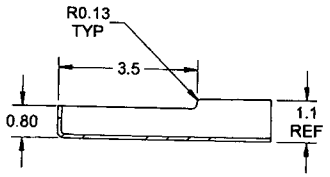
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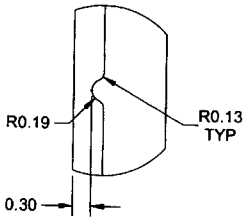
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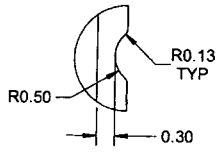
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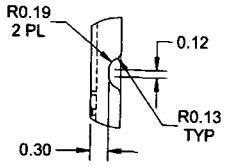
SECTION O-O B6-14
SCALE 1.3X



DETAIL R B3-10 C3-10 B2-12
SCALE 4X



DETAIL S B3-10 C2-12
SCALE 4X



DETAIL T C2-14
SCALE 4X

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DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. D4634 REV. F
MFG. APPR.		SHEET 17 OF 17
APPROVED		TITLE CENTER CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.02.03	

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Description: Fwd Center Ceiling Panel		**Work Order:**	B120783
Inspection Drawing: 4634-1	**Rev:** F	**Part Number:**	D4634-1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.00	+/-0.030	12.00	✓		5-Feb-21	
24.00	+/-0.030	24.0	✓		"	
39.75	+/-0.030	39.75	✓		"	
11.66	+/-0.030	11.66	✓		"	
31.41	+/-0.030	31.40	✓		"	
1.300	+/-0.010	1.306	✓		5 Feb-08	
Ø0.250	+0.005 -0.001	0.254	✓		"	
Ø2.030	+0.002 -0.001	2.035	✓		"	
4.667	+/-0.010	4.668	✓		"	
2.334	+/-0.010	2.336	✓		"	
Ø3.50	+/-0.010	353	✓		"	
Ø0.191	+0.005 -0.001	1.94	✓		"	
3.80	+/-0.030	381	✓		"	
0.63	+/-0.030	0.64	✓		"	
1.25	+/-0.030	1.235	✓		"	
10.20	+/-0.030	1020	✓		5 Feb-21	
11.25	+/-0.030	11.25	✓		"	
.50	+/-.030	.521	✓		5 Feb-08	
1.38	+/-.030	1.40	✓		"	
.35	+/-.030	.364	✓		"	

Measured by:	Checked By: DAS 16 9-89	QC inspector: DAS 16 9-89	Engineering Approval (*if necessary*):
Date 14/7/21	Date 14/07/21	Date 14/07/21	Date